

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004040**Date Inspected:** 16-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

Ultrasonic verification of weldments

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for random observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received NDT notification number 1042 from ZPMC and proceeded to perform Ultrasonic verification (UT) on Side plate "WT" stiffeners identified as SP099-001 welds 044~050, 052, 054, 056, 058 and 060. SP312-001 welds 046~505, 052, 054, 056 and 060. ZPMC had performed 25% UT testing for the weldments as outlined in the contract documents and had accepted the percentage as acceptable. This QA inspector performed 10% UT verification on the percentage that was performed by ZPMC and at the time of the QA review found the areas appeared to be within contract documents. After ZPMC had performed their testing and accepted the weldments. ZPMC also informed Caltrans QA of notification number 1041 for skin plate E, NSD1-SA76 and NSD1-SA10 for QA review with UT. When this QA inspector arrived to perform the NDT he was informed by QC that the welds were not ready and ZPMC had only performed half of their UT testing at this time and ZPMC was flipping the plate over 180° to gain access to the opposite side for testing. ZPMC was removing the primer paint for the UT testing at the time QA was in this bay.

Summary of Conversations:

As stated above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 1-381-694-2685, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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